Intercure® 324

Epoxy

PRODUCT DESCRIPTION

A two component, high solids, low VOC, epoxy zinc phosphate/micaceous iron oxide primer offering excellent barrier protection, low temperature cure and rapid overcoating properties.

Pigmented with zinc phosphate anti-corrosive pigment to comply with the requirements of BS5493:1977

INTENDED USES

As a primer for steelwork intended for use in a wide range of environmental conditions including offshore, chemical and petrochemical plants, industrial buildings, pulp and paper mills, power plants and bridges.

The rapid curing and overcoating properties of Intercure 324 provide production flexibility, making this product suitable for use both in new construction and on site as an industrial maintenance coating.

PRACTICAL INFORMATION FOR INTERCURE 324

Colour	Sand
Gloss Level	Matt
Volume Solids	72%
Typical Thickness	75-100 microns (3-4 mils) dry equivalent to 104-139 microns (4.2-5.6 mils) wet
Theoretical Coverage	9.60 m²/litre at 75 microns d.f.t and stated volume solids 385 sq.ft/US gallon at 3 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray, Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
5°C (41°F)	3 hours	10 hours	7 hours	Extended[1]
15°C (59°F)	2 hours	6 hours	4 hours	Extended[1]
25°C (77°F)	1.5 hours	3.5 hours	3 hours	Extended[1]
40°C (104°F)	45 minutes	1 hour	1 hour	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 38°C (100°F); Part B 27°C (81°F); Mixed 33°C (91°F)	
Product Weight	1.62 kg/l (13.5 lb/gal)	
VOC	200 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)
	252 g/lt	Chinese National Standard GB23985

Coating hazard marker GB 30981.2-S-Pb≤1000-NC Qualified for GB 30981.2-2025

See Product Characteristics section for further details

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2019.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intercure 324, the surface should be reblasted to the specified visual standard.

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

A sharp, angular surface profile of 50-75 microns (2-3 mils) is recommended.

Intercure 324 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

Shop Primed Steel

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

APPLICATION

Mixing

Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.

(1) Agitate Base (Part A) with a power agitator.

(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.

Mix Ratio

3.0 part(s) : 1.0 part(s) by volume

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
90 minutes	90 minutes	90 minutes	45 minutes

Airless Spray	Recommended	Tip Range 0.38-0.58 mm (15-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended (5% thinning required)	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
Roller	Suitable - small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
Thinner	International GTA220	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.	
Cleaner	International GTA822		

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.

Clean Up

Clean all equipment immediately after use with International GTA822. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

PRODUCT CHARACTERISTICS

Intercure 324 is capable of curing at temperatures below 0°C (32°F). However, this product should not be applied at temperatures below 0°C (32°F) where there is a possibility of ice formation on the substrate.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

This product must only be thinned using recommended International GTA220 thinners. The use of alternative thinners, particularly those containing ketones, can severely inhibit the curing mechanism of the coating.

Over-application should be avoided as thick films will not be as good a substrate for topcoat adhesion after ageing as those at the specified thickness. When using as a blast holding primer avoid over-application as thick films may suffer from cohesive film splitting if subsequent coats are also over-applied.

Over-application of Intercure 324 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

The maximum overcoating interval will be dependent upon the integrity of the exposed film. A film of 75 microns (3 mils) dry film thickness will normally be overcoatable after 6 months exposure provided it is adequately cleaned and any areas of mechanical damage repaired.

Absolute measured adhesion of topcoats to aged Intercure 324 is less than that to fresh material, however, it is adequate for the specified end use.

Intercure 324 is preferred for use with systems for chemical environments where zinc based materials can be subject to attack in both acidic and alkaline conditions.

Intercure 324 is not intended for use as a primer for steelwork which may be subjected to continuous immersion conditions.

This product is not available in pale and pastel shades due to a tendency to discolour rapidly. Additionally, in common with all epoxies Intercure 324 will chalk on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Intercure 324 can also be used as a primer for substrates other than blasted steel, e.g. stainless steel, alloys, etc. Consult International Protective Coatings for further details.

This product has the following specification approvals:
- BS5493:1977 KP1A
- UK Department of Transport Item No.111

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Intercure 324 will normally be applied to suitably prepared steel, e.g. blast cleaned. However, if necessary, application over prefabrication blast primers can be performed. Consult International Protective Coatings for further details.

Recommended topcoats/intermediates are:

Intercure 384	Intergard 740
Intercure 420HS	Interseal 670HS
Intercure 422	Interthane 870
Interfine 629HS	Interthane 990
Intergard 410	Interzone 505
Intergard 475HS	Interzone 954
Intergard 540	Interzone 1000

For other suitable topcoats/intermediates, consult International Protective Coatings.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult AkzoNobel for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	15 litre	20 litre	5 litre	5 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	29.6 kg	5.36 kg

STORAGE	Shelf Life	12 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

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